

CLAIMS:

Sub A' 1. A method of decorating a molded article comprising:
providing a transfer having a flocking layer, a release sheet on one side of the flocking and a layer of binder adhesive on an opposite side of the flocking;

securing the release sheet to an interior wall of a mold in which the article is made; and

molding the part such that resin contacts the layer of binder adhesive;

cooling the mold;

ejecting the part; and

removing the release sheet from the transfer.

Sub D' 2. The method of claim 1 wherein the release sheet is affixed to the mold base with an adhesive.

3. The method of claim 1 wherein the release sheet is affixed to the mold by vacuum.

4. The method of claim 1 including a step of preventing the resin from entering interstitial spaces between the flocking.

5. The method of claim 4 wherein the preventing step includes forming a dam around the perimeter of the transfer.

6. The method of claim 5 wherein the dam is formed by placing a barrier in the mold, the transfer being positioned within the barrier.

7. The method of claim 5 wherein the dam is part of the transfer, the dam comprising a built up section of binder adhesive around the periphery of the transfer.

8. A method of decorating a molded article comprising:
coating a release sheet with a release adhesive;

flocking flock into said release adhesive by imbedding a first end of said flock into the release adhesive to result in at least one pattern of flock arranged to form a predetermined design adhered to said release sheet;

forming a barrier around the periphery of said flock;

affixing said release sheet to the interior surface of a mold; and

molding an article over said adhesive binder and thereby permanently bonding said flock to said article.

9. The method of claim 8 wherein said step of forming said barrier comprises applying a binder adhesive to said flock; said binder adhesive being built up around the periphery of said flock.

10. The method of claim 8 wherein said step of forming said barrier comprises providing a dam on the surface of the mold, the transfer being applied to the mold within the dam.

11. The method of claim 8 wherein the step of molding the article comprises injecting molten resin into the mold.

12. The method of claim 11 wherein the resin is initially injected at a first pressure, the first pressure being sufficiently low to prevent dislodgment of the transfer from the mold wall; and then providing a second injection of the resin at a second higher pressure.

13. The method of claim 11 wherein the injected resin has a lower melting point than the release adhesive.

Add A 2
Add B 1
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